

Date: Tuesday, 10/30/2007 2:50:19 PM
User: Kim Johnston

Process Sheet

49

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE ASSEMBLY
Job Number : 35451B -1
Estimate Number : 11180
P.O. Number : N/A Part Number : D2282043
This Issue : 10/30/2007 S.O. No. : N/A Drawing Number : D2282 REV E
nrst Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : E
Previous Run : 33958B Material : N/A
Written By : Due Date : 12/2/2007 Qty: 100 Um: Each
Checked & Approved By : KJ 07 10 31
Comment : Est Rev. A Removed from 9 Digit 05-12-02 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D2281

Jack Saddle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2281

Saddle

B34181 x23

B35471

FC 07/12/14

(100)

2.0

D22827

Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2282-7

tube

B35638

x20

FC 07/12/14

(100)

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS

Filling Rod

Dwg Rev: E

M104977

FC 07/12/14

(100)

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

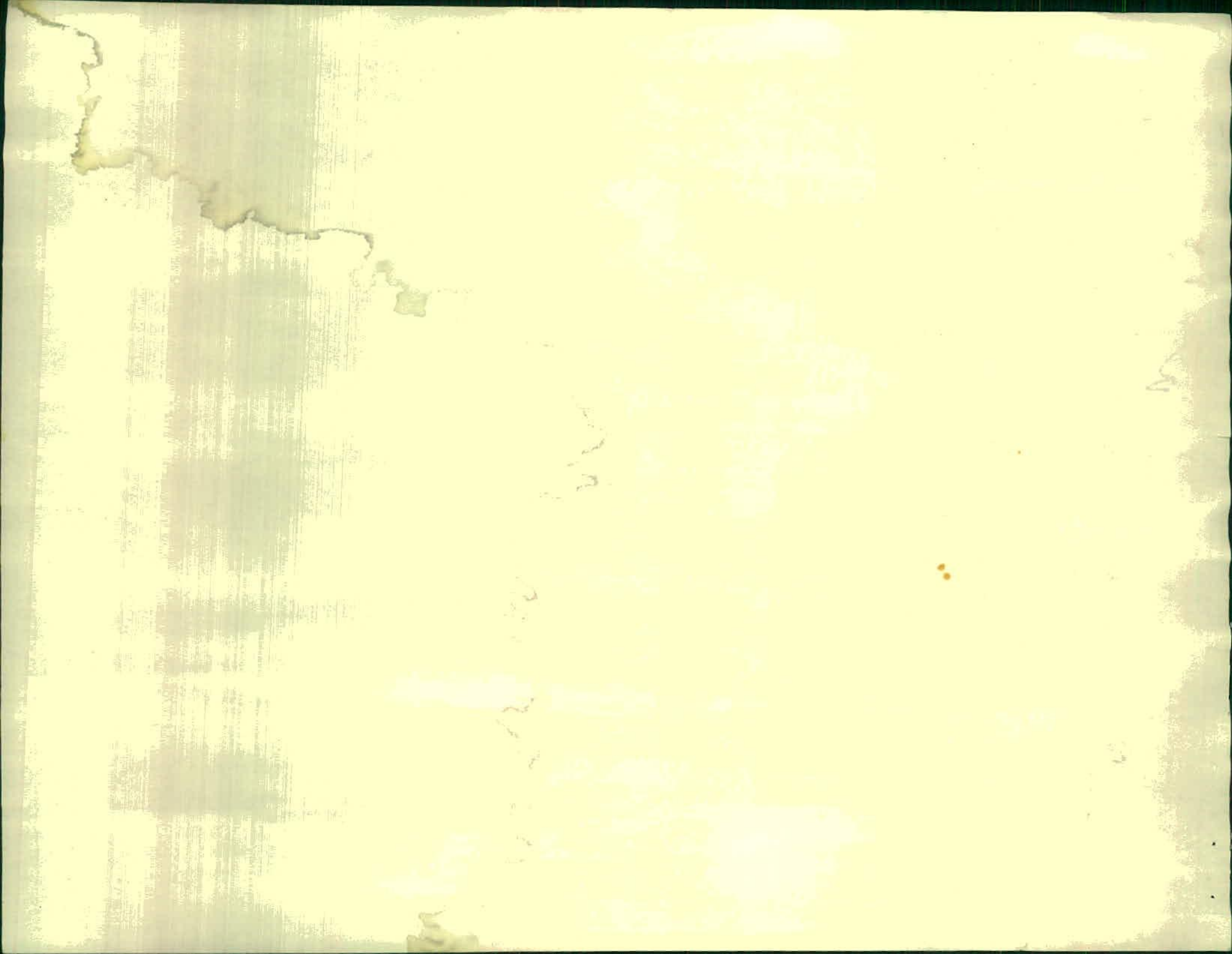
PD 07-12-20

(100)

1875

10/11/19

Chapman & Hall

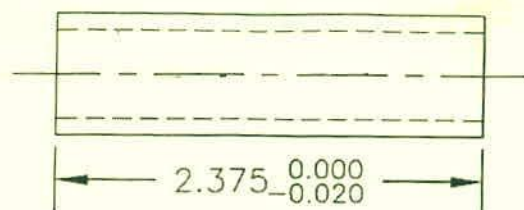
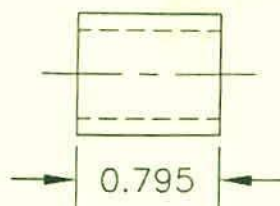
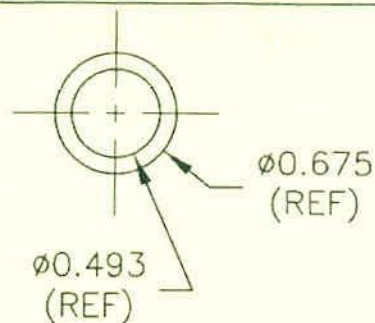


DART

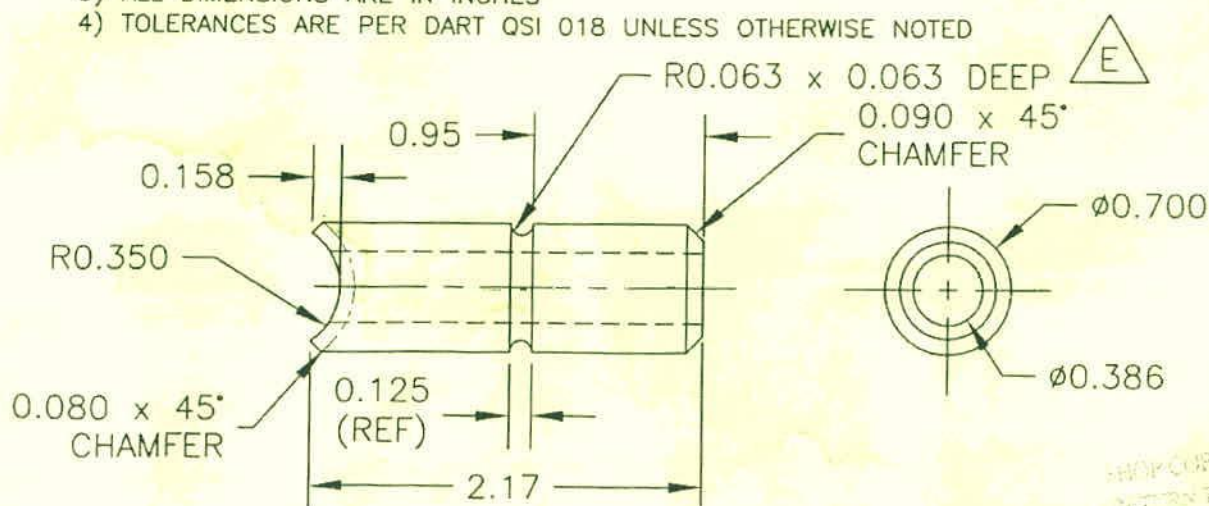
DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES	SCALE 1:1	
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

BS/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

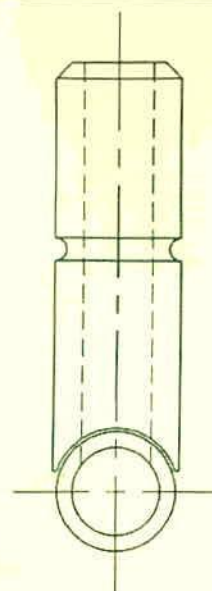
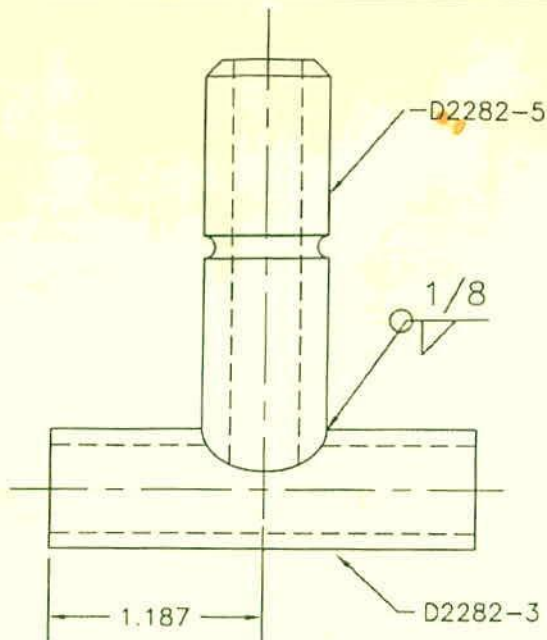
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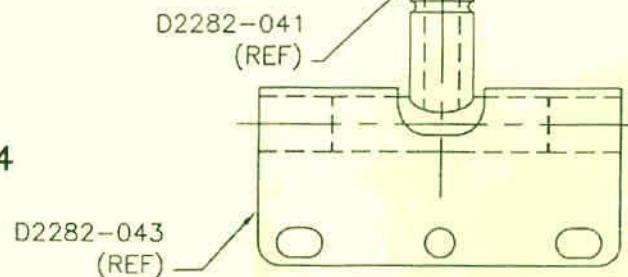
DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>up</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

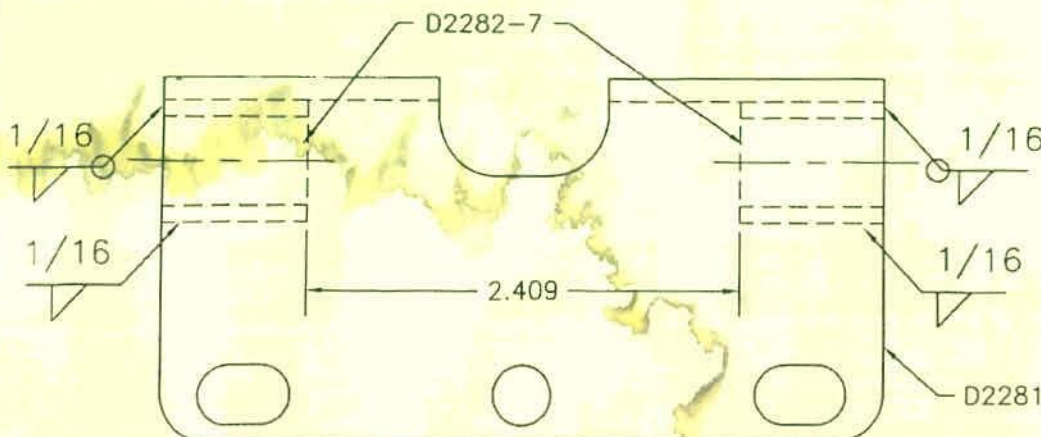


RELEASED
[Signature]
05/09/16

D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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